






Work Order ID 52583



October 2, 2009 11:21:51 AM



Page 1

Item ID: D3017-11 Accept  Setup Start 
Revision ID: A Stop 
Item Name: cap
Start Date: 02/10/2009 Start Qty: 10.00  Cust Item ID:
Required Date: 20/10/2009 Req'd Qty: 10.00  Customer:


Reference:

Approvals: Process Plan: BS Date: 09-10-2 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3017	Rev A

100	FLOW WATER JET	0.00							
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Waterjet  4130 .640 9-11-5
FLOW CNC Waterjet
Memo
1-Cut as per Dwg D3017
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary = 7 m-l 09/11/05 (BSX) (35)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC 9-11-5
Quality Control Memo

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Item ID:	D3017-11	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	cap					
Start Date:	02/10/2009	Start Qty: 10.00		Cust Item ID:		
Required Date:	20/10/2009	Req'd Qty: 10.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	27 S or 1 u log			cancel (35) f			
130 Packaging Packaging	Packaging Memo Identify and bag with light oil (Vactra oil #2), then Stock Location: _____	0.00 0.00				9/11/9	(35) SP		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/11/09 *J B/ 09-11-9 (35)			

Picklist Print

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Work Order ID: 52583



Parent Item: D3017-11RevA



Parent Item Name: cap



Start Date: 02/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4130NS.049  4130 Sheet .049		Purchased	No			100	sf	26.9300	0.0421 		18 9-11-5	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	26.93	
11612	11.43	
16443	15.5	

16443



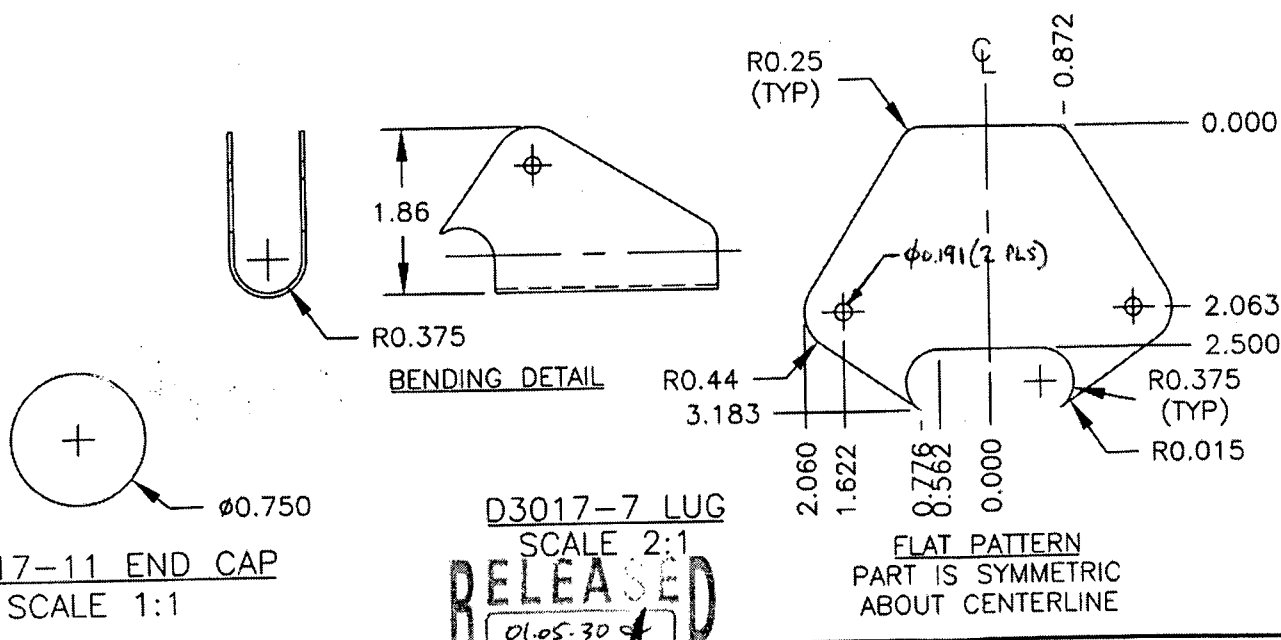
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY SCALE 1:1	
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

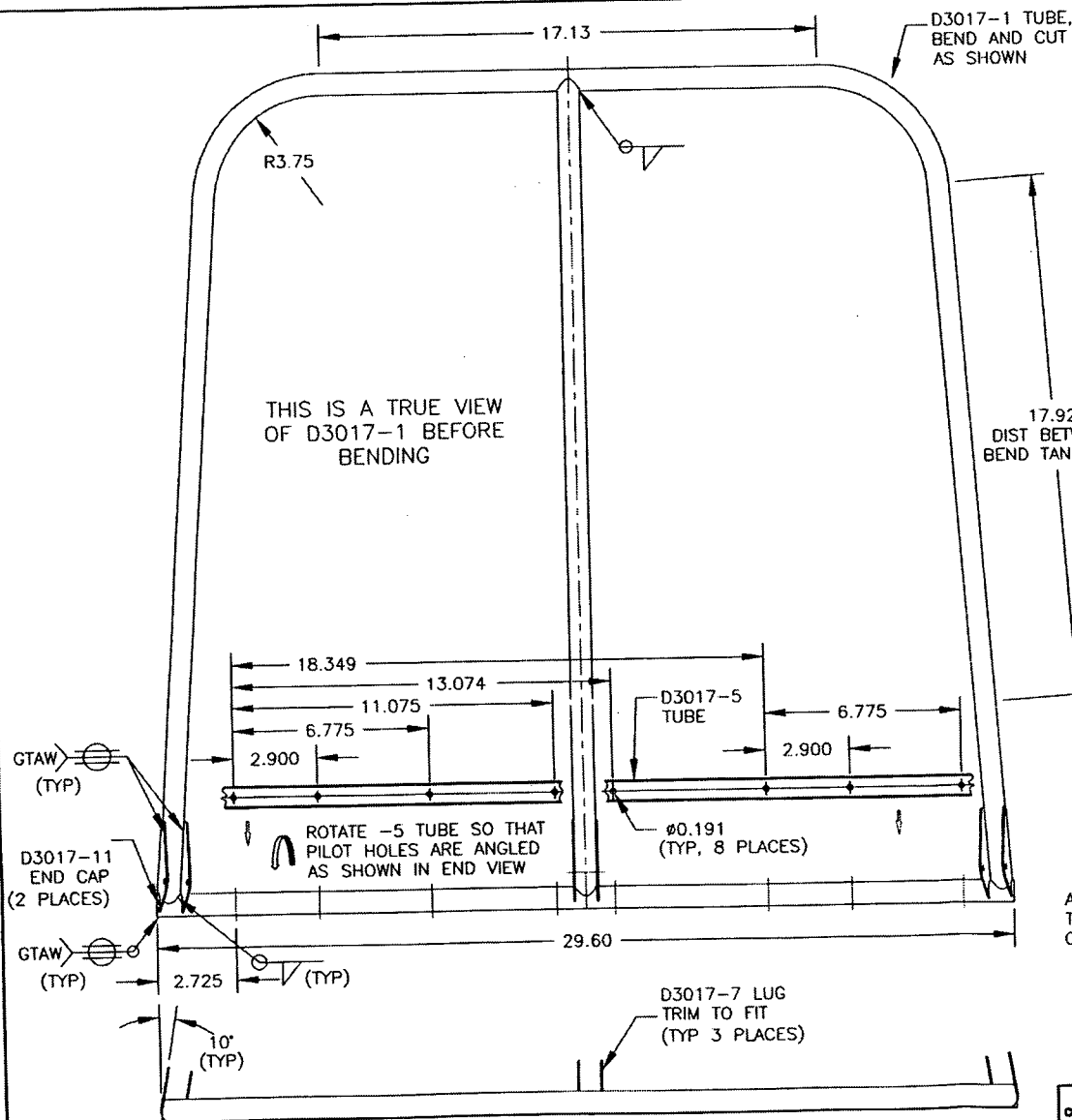
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 52583
PL 09-10-2



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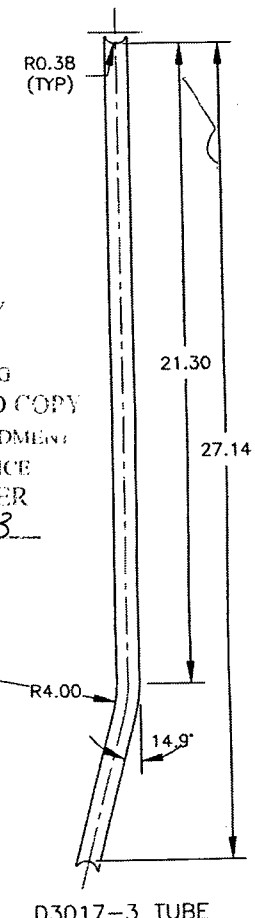
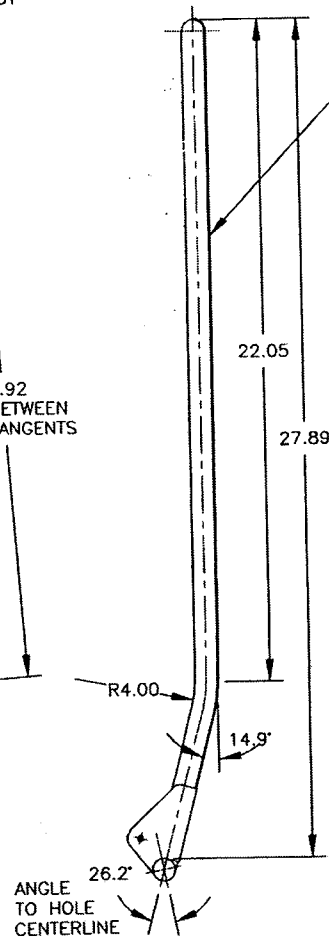


D3017-1 TUBE,
BEND AND CUT
AS SHOWN

17.92
DIST BETWEEN
BEND TANGENTS

DRILL $\phi 0.128$ HOLES TO LINE UP
WITH D3023-1 BACK PANEL

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D3017-3 TUBE

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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DATE 01.05.18		TITLE BACK FRAME ASSEMBLY		SCALE 1:4	